

Work Order ID 84992

84992

Page 1

May-31-12 9:13:38 AM

Item ID: D2574

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft In 205

Start Date: 30/05/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 08/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/31

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2574	Rev E								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1								
HAAS 1		0.00							
HAAS CNC vertical machine #1	Memo Program Batch No. <u>84992</u> Double check by: <u>FL</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3- Machine Step No 3 per Folio FA051 and insp								
110		0.00							
110	CONVENTIONAL MILLING MACHINE								
Mill Conv		0.00							
Conventional Milling Machine	Memo Machine keyway as per dwg D2573 & D2574								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								

FL 12/07/17

FL 12/07/25

FL 12/07/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

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Start Date: 30/05/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 08/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
13
9-89

12/7/26

8

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

8

76

12-7-30

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:45

3000F

12:15

8X

mf
12/07/30

m121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 84992

84992

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May-31-12 9:13:38 AM

Item ID: D2574

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft In 205

Start Date: 30/05/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 08/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

8x 6 12/07/30

170

Identify as per dwg & Stock Location ST

0.00

170

Packaging

Memo

442

0.00

Packaging

12/7/30

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/31

12/07/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-31-12 9:13:42 AM

Page 1

Work Order ID: 84992

84992

Parent Item: D2574

D2574

Parent Item Name: Saddle, Aft In 205

Start Date: 30/05/2012

Required Date: 08/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-005		Manufactured	No			110	Each	25.0000	1	8			
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D6101-005

Saddle Billet

**

8

sf 12/07/11

Location

Loc Qty

Loc Code

MAT041

2

76838

2

MAT044

23

79874

19

81973

4

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>24992</i>
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.001		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.502	.502	.500	.502		
J	1.174	1.184		1.179	1.179	1.149	1.179		
K	0.558	0.578		.568	.568	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.126	.126	.126	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.240	.242		
W	0.115	0.135		.128	.126	.128	.129		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.626	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.242	.242	.242		
AE	1.500	1.520		1.5135	1.513	1.514	1.514		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.252		
AI	2.000	2.020		2.006	2.004	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>FK</i>
Date:	<i>12/07/17</i> / <i>12/07/25</i>

Audited by:	<i>13</i>
Date:	<i>12/7/26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 04992
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

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				Recorded Actual Dimensions					
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G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
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K	0.558	0.578		.568	.568	.568	.567		
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M	1.365	1.375		1.370	1.370	1.370	1.370		
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W	0.115	0.135		.128	.125	.129	.130		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
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AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.004	2.004	2.0045	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	F.K.
Date:	12/07/19 / 12/07/25

Audited by:	DAS
Date:	12/7/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
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Dart Aerospace Ltd

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